S.O. No. :

Type

User:

Wednesday, 16/04/200

Julie Lecoca

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 38646 : 10437 **Estimate Number**

P.O. Number

: 16/04/2008 This Issue

: NC Prsht Rev.

First Issue : 11

: 38112 Previous Run

Written By

Checked & Approved By

Comment

В 05.10.14 Added step 9, dwg rev B

: SMALL /MED FAB

Est Rev:C Now on Waterjet 06-10-26 JLM

Drawing Name

: WEARPLATE

: D33191 Part Number

: D3319 REV. B **Drawing Number** : N/A

Project Number **Drawing Revision** Material

Due Date : 25/04/2008 Qty:

12 Um:

Each

Additional Product

Job Number:



Seq. #:

M1010S18GA

Description: **Machine Or Operation:**

1010/1025/A21/6aA SHEET .048

KJ/EC



Comment: Qty.: 0.6594 sf(s)/Unit Total: 7.9128 sf(s)

1010/1025/A21/6aA SHEET .048

Batch: 106348

2.0 WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: Prog Rev:

IB 8-4-18

2-Deburr if necessary

QC2 3.0

INSPECT PARTS AS THEY COME OFF MACHINE



PARTS AS THEY COME OFF MACHINE Comment: INSPECT

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

Dart Aerospace Ltd

W/O:			WC	ORK ORDER CHANGES					
DATE	STEP	PROC	EDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		*							
Part No		PAR #:	_ Fault Cate	gory: N	CR: Yes	No DQ	\:	_ Date: _	
6					QA: N	I/C Closed	d:	_ Date: _	
NCR:		W	ORK ORDI	ER NON-CONFORMANO	E (NCF	₹)			
		Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
							1		

NOTE: Date & initial all entries

Date: Wednesday, 16/04/2008 3:53:39 PM User: Julie Lecoca **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: WEARPLATE Job Number: 38646 Part Number: D33191 Job Number: Seq. #: Machine Or Operation: Description: BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE 1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: _______ 2- Form flat on press using DT8776 block (2 7.0 QC6 DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK 8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 1- Layout weld location as per Dwg D3319 using jig D3319-1T3 2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: Batch Part Number Description Qty 1338646 H106390 A/R N/A 7560 Hardcoat Rod QC10 VISUAL INSPECTION OF GROUND WELD 9.0 S.103 Comment: VISUAL INSPECTION OF GROUND WELDS QC5 INSPECT WORK TO CURRENT STEE 10.0 #3 #4 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING 11.0 106442 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSIO 12.0 QC3 Comment: INSPECT POWDER COAT PACKAGING 1 13.0 Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 Page 2 Form: rprocess

Dart Aerospace	Ltd
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W/O:			₩C	RK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			160							
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes	No DQ	A:	_ Date: _	ii
								d:	_ Date: _	2)
NCR:			WORK ORDI	ER NON-CONFORM	IANCE	(NCF)			
DATE	STEP	Description of NC			ection B	0: 0	Verific		Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	!	Sign & Date	Section	on C	Chief Eng	QC Inspector
								Я		
								В		
								.51		
								20		
								39		
								20		

NOTE: Date & initial all entries

Date: User Wednesday, 16/04/2008 3:53:39 PM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38646

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description:

and Stock

Location:

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mF 08-04-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Category:	NCR: Yes	No DQ	Δ.	Date:	

QA: N/C Closed: ____ Date: ___

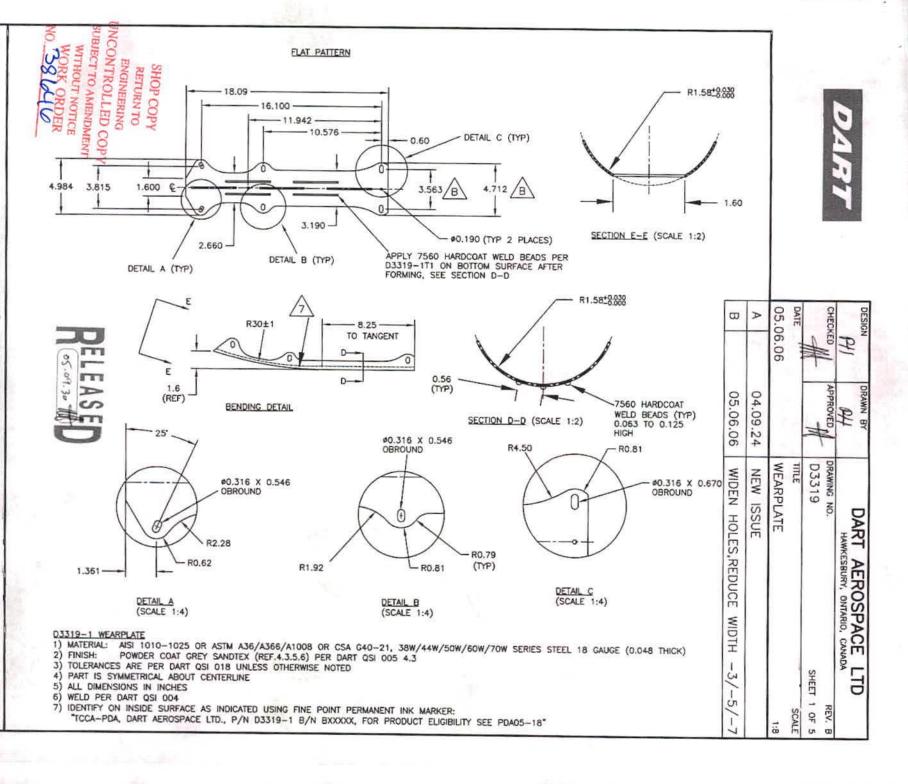
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC	Corrective Action Section B		Verification			
DATE	STEP Description of NC Section A		Initial Action Description Sign & Chief Eng Chief Eng Date		Section C	Approval Chief Eng	Approval QC Inspector	
			i i					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38646
Description: Wearplate	Part Number:	D3319-1
Inspection Dwg: D3319 Rev: B		Page 1 of 1

	X First	Article	Pro	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.984	+/-0.010	4.993	*			
1.600	+/-0.010	1.603	*			
2.660	+/-0.010	2.666	*			
3.190	+/-0.010	3.197	*			
3.563	+/-0.010	3,564	*			
4.712	+/-0.010	4.709	*			
0.60	+/-0.030	1605	*			
10.576	+/-0.010	10.576	¥	9		
11.942	+/-0.010	11.947	×.			
18.09	+/-0.030	18.09	x			
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	1318	× .546	×		
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	.316	× ,673			
Ø0.190	+0.005/-0.001	£91.	×			
Measured by:	R Audited	d by:		Prototy	rpe Approval:	N/A
Date:	TD .		18	110.01	Date:	N/A

Approved		Change	Date	Rev
Gidl	KJ/JLM X	New Issue	07.05.31	Α
1	KJ/JLM X	New Issue	07.05.31	A



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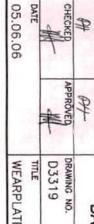
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DETAIL G (TYP)

DART RT AEROSPACE L

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REV.

OF 5

SCALE

WEARPLATE SHEET

APPLY 7560 FLAT PATTERN HARDCOAT WELD BEADS - 75.52 -PER D3319-3T1 UNCONTROLLED COP SUBJECT TO AMENDM ON BOTTOM SURFACE AFTER RETURN TO 6 SHOP COT FORMING, SEE 52.890 SECTION H-H 30.790 8.690 2.690 B 4.518 5.063 6.163 2.940

> DETAIL F (TYP) (TYP 4 PLACES) 2.690 -DETAIL J (TYP) B H-H-

2.940

BENDING DETAIL

D3319-3 WEARPLATE

3.527

/B

DETAIL E (TYP)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Ø0.190

- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES

2.940 -

- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX. FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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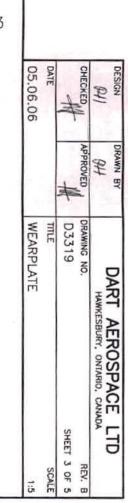
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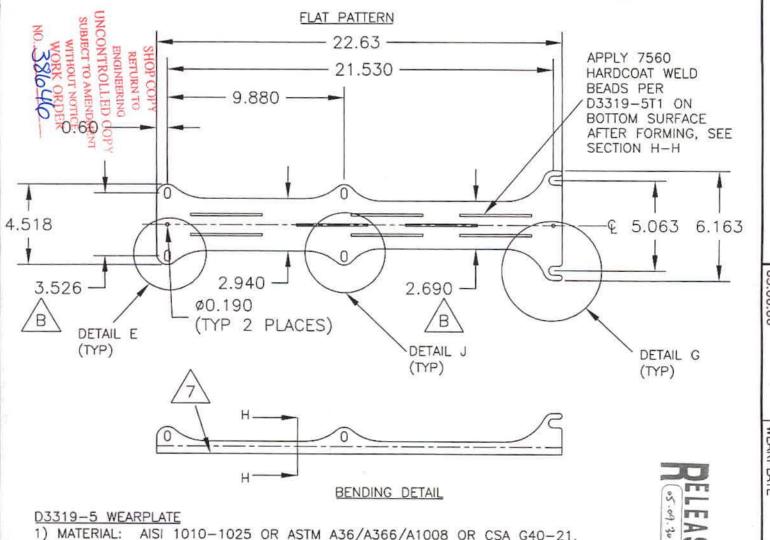
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OR

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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004

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PURPOSE

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7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

至

1:5

DRAWING NO.

DART AEROSPACE LTD SHEET 4 OF 5

ENGINEERING 69
UNCONTROLLED COPY
SUBJECT TO AMERICAN FLAT PATTERN SHOP COPY APPLY 7560 HARDCOAT WELD 12.75 BEADS PER D3319-7T1 ON BOTTOM SURFACE AFTER 11.650 FORMING, SEE SECTION H-H 3.526 B 5.063 6.163 2.690 DETAIL E В (TYP) DETAIL G (TYP) Ø0.190 (TYP 2 PLACES) BENDING DETAIL

D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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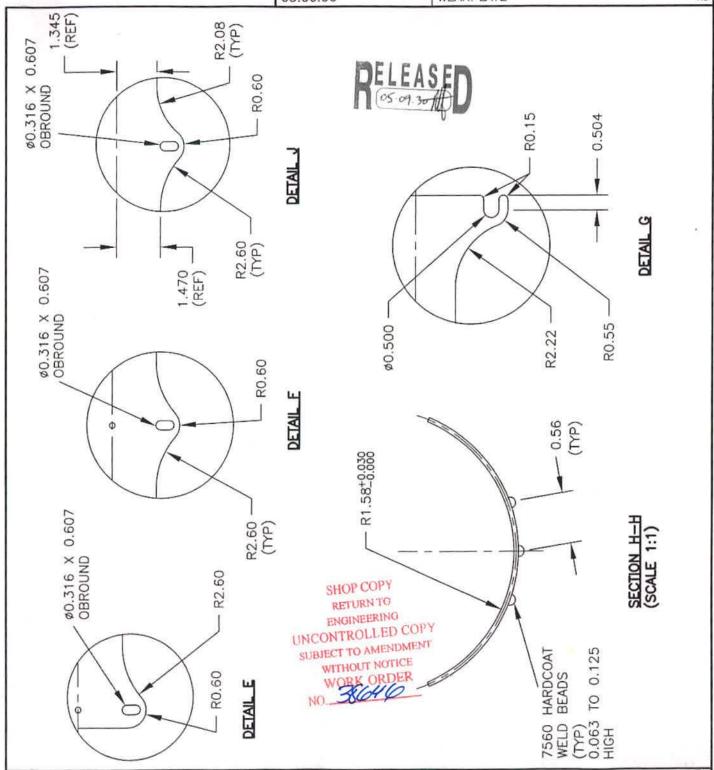
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DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 5 OF 5
DATE	1	TITLE	SCALE
05.06.06		WEARPLATE	1:3



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